



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Garl

D3391-023
Job Sheet 193563



Part No: D3391-023

Job Qty: 1 pcs

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: *SOLD*

Description: *order 15313*

Note: DWG REV J SHEET 2 and 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/26/19	0.00	0.00	Start Up Skid tubes-1		<i>MBL</i>
100	Skid tubes - <i>2-B4B</i>	1		4/26/19	0.00	2.11	Skid tubes - 1		
		pcs					Skid tubes - 2		
							Skid tubes - 3		<i>MBL</i>
							Skid tubes - 4		
							Skid tubes - 5		
							Skid tubes - 6		
							Skid tubes - 7		
110	QC 5	1		4/26/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS 24	MAY 30 2019
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Handfinish - 1-1 Chemical-B4B	1		4/26/19	0.00	0.38	Handfinish - 1 - 1 - B4B		
		pcs					Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		



Container No: S175027



Part: D3391 - 023

Job No: 193563

Serial No/Batch: S175027

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/24/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					Handfinish - 1 - 4 - B4B						
					Handfinish - 1 - 5 - B4B	ry					
					Handfinish - 1 - 6 - B4B						
					Handfinish - 1 - 7 - B4B						
					Handfinish - 1 - 8 - B4B						
					Handfinish - 1 - 9 - B4B						
					Handfinish - 1 - 10 - B4B						
					Handfinish - 1 - 11 - B4B						
					Handfinish - 1 - 12 - B4B						
					Handfinish - 1 - 13 - B4B						
					Handfinish - 1 - 14 - B4B						
					Handfinish - 1 - 15 - B4B						
					Handfinish - 1 - 16 - B4B						
					Handfinish - 1 - 17 - B4B						
					Handfinish - 1 - 18 - B4B						
					Handfinish - 1 - 19 - B4B						
					Handfinish - 1 - 20 - B4B						
					Handfinish - 1 - 21 - B4B						
					Handfinish - 1 - 22 - B4B						
					130 QC 7	1 pcs	4/26/19	0.00 0.00		QC 7 - 10	
										QC 7 - 13	
										QC 7 - 14	
QC 7 - 15											
QC 7 - 17											
QC 7 - 18											
QC 7 - 19											
QC 7 - 2											
QC 7 - 28											
QC 7 - 3											
QC 7 - 30											
QC 7 - 34											
QC 7 - 36											
QC 7 - 37											
QC 7 - 41											
QC 7 - 47											
QC 7 - 48											
QC 7 - 51											
QC 7 - 58											
QC 7 - 59											
QC 7 - 60	MLG										
QC 7 - 9											
QC 7 - 68											
QC 7 - 50											
QC 7 - 67											
QC 7 - 40											
140 Skidtubes - 2 - B4B	1 pcs	4/26/19	0.00 2.11		Skidtubes - 1 - B4B						
					Skidtubes - 2 - B4B						
					Skidtubes - 3 - B4B	MLG					
					Plex 4/16/19 1:48 PM Dart.lajeunesse.marie						

150 QC 5	1 pcs	4/26/19	0.00 0.00	Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Skidtubes - 3 - B4B	1 pcs	4/26/19	0.00 2.11	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	4/26/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS
				QC 10 - 24	24
				QC 10 - 43	9-89
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	4/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
185 Handfinish - 2-1 Pressure-B4B	1 pcs	4/26/19	0.00 0.00	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	⊙ JUN 10 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
191 Spray Paint - 2 - B4B	1 pcs	4/26/19	0.00 0.91	Spray Paint - 1 - B4B	⊙ 19-6-16
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	

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				Spray Paint - 4 - B4B	
192 Outsource - 11 - Paint	1 pcs	4/26/19		ATE003-VC	NR
193 Packaging 2-1 - Receive - B4B	1 pcs	4/26/19	0.00 0.00	Packaging 2 - 1 - B4B	NR
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
200 QC 14	1 pcs	4/26/19	0.00 0.00	QC 14 - 15	ML 19-6-18
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	4/26/19	0.00 0.38	Handfinish - 4 - 1 - B4B	ML 19-6-18
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 -	

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DAS
15
9-89

				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1	4/26/19	0.00 0.00	QC 5 - 10	
	pcs			QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 3-1 - Stock - B4B	1	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

DAS
40
9-00

SEP 10 2019

W/B

9/12/2019

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
260 QC 21 - SA	1 pcs	4/26/19	0.00 0.00		QC 21 - SA - 21	Date 21 SEP 12 2019 9-00
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Skid tubes - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and Descriptions: drill only 1 fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skid tube as per Dwg D3391 6-Deburr, scribe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pls and clicos to ensure perfect allignment, open up previously tranfer drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499" D3391-021 BATCH: 1/A 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker, ***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG*** Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside

110 - QC5- Inspect part completeness to step on W/O
120 - Chemical Conversion Coat per QSI005 4.1
130 - QC7-Inspect Chemical Conversion Coat
140 - Skid tubes - 1-Open float bag holes as per dwg 2-C-sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 19-12-08
batch#: 5174342 NOTE: ENSURE WEB IS INSERTED IN AFT END OF TUBE
150 - QC5- Inspect part completeness to step on W/O
160 - Skid tubes - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush AIR M139011
170 - QC10- Inspect visual per QSI004- ground welds
180 - QC5- Inspect part completeness to step on W/O
185 - Pressure Wash per QSI005 4.3/ Clean and remove all marking - Re-alodine
191 - Spray Paint / NDT Room - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5189640
PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: 5188693
193 - Receive & Inspect for Damage & Mat'l Certs
200 - QC14- Inspect Spray Paint
230 - Assemble as per dwg - 1-Install Inserts as per Dwg
240 - QC5- Inspect part completeness to step on W/O
250 - Identify as per dwg & Stock Location:
260 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation
D2500-1-100	Skid tube Extrusion	1 pcs (1 ea)	90-Start up Operation
D3389-1	Web	1 pcs (1 ea)	140-Skid tubes - 2 - B4B
D3681-1	Spacer	5 pcs (5 ea)	160-Skid tubes - 3 - B4B
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-Handfinish - 4-1-Assembly-B4B
D3591-1	Bushing	2 pcs (2 ea)	230-Handfinish - 4-1-Assembly-B4B

010442
Container
D163253
517267
5145873
5057257
5122131

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	116	0
140-Skid tubes - 2 - B4B	D3389-1	1	9	0
160-Skid tubes - 3 - B4B	D3681-1	5	156	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	20	8,655	0
	D3591-1	2	29	0

Part Specifications

Specifications could not be found.

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QTY	QTY	PART NUMBER	DESCRIPTION
401	405	D5391-041	FLOAT END TUBE ASSEMBLY
8	X	D5391-045	FLOAT END TUBE ASSEMBLY
1		D5391-051	FLOAT TUBE ASSEMBLY
		D5391-073	MID TUBE ASSEMBLY
		D5391-075	AFT TUBE ASSEMBLY
1		D5391-101	FLOAT TUBE ASSEMBLY
		D5391-123	MID TUBE ASSEMBLY
	1	D5391-095	AFT TUBE ASSEMBLY
2	2	D5591-1	BUSHING
4	3	D5872-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN8CA	BOLT
4	4	AN8CA	BOLT
10	10	AN5CA	BOLT
28	28	NAS114C0352R	WASHER
10	10	NAS114C0352R	WASHER
3	3	NS2709SCA-12	SCREW
3	3	NAS114C0432R	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 193503 1904-14

J	I	ML	16.01.14
INCORPORATED DSI 8733, REFORMAT DRAWING CHANGED CRORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8, LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D8-4 ZN D2-4, ZN D7-3, ZN D3-5	XDF	11.10.13
DRAWING UPDATED TO CURRENT STANDARDS. SHIT 1 PL, ADDED D3891-1 BUSHING, ZN C3 60.438 DIM WAS 4 PL, ADDED 60.489 DIM AND D3891-1 BUSHING. SHIT 2 PL, ADDED D3891-1 BUSHING, ZN C3 60.438 DIM WAS 4 PL, ADDED 60.489 DIM AND D3891-1 BUSHING. (FOR REPLACEMENT SEE DSI 8364 & NCR 08-074)	DRAWING UPDATED TO CURRENT STANDARDS. SHIT 1 PL, ADDED D3891-1 BUSHING, ZN C3 60.438 DIM WAS 4 PL, ADDED 60.489 DIM AND D3891-1 BUSHING. SHIT 2 PL, ADDED D3891-1 BUSHING, ZN C3 60.438 DIM WAS 4 PL, ADDED 60.489 DIM AND D3891-1 BUSHING. (FOR REPLACEMENT SEE DSI 8364 & NCR 08-074)	AJS	08.08.20
REPLACE WAS INSERTS W/AELS INSERTS SWITCH TO D3870-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DING REORGANIZED FOR CLARITY	REPLACE WAS INSERTS W/AELS INSERTS SWITCH TO D3870-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DING REORGANIZED FOR CLARITY	DC	07.07.31
ADD S3 WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	ADD S3 WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
CHANGE TOLERANCE, EASE MANUFACTURE	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
UPDATE TOLERANCE, CHANGE HOLE SIZE	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.28
LENGTHEN AFT EXTENSION	LENGTHEN AFT EXTENSION	PH	06.06.27
DRAWING UPDATES	DRAWING UPDATES	PH	06.08.17
A NEW ISSUE	A NEW ISSUE	PH	06.02.07
REV	DESIGN	BY	DATE
DRAWN	PH		
ML			
CHECKED	CP		
MFG. APPR.	D3391		
APPROVED	TITLE		
DE APPR.	412 FLOAT SKIDTUBE		
DATE	16.01.14		

REV. J
SHEET 1 OF 11
SCALE
NTS

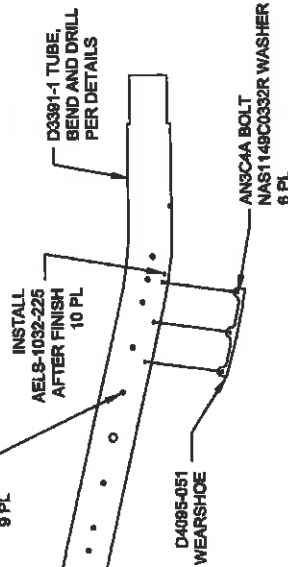
DART AEROSPACE USA, INC
EUGENE, OR

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RELEASED ON 2016-04-28 BY NLS-56

INSTALL D3670-4200 SPACER
SEAL WITH MAGNIBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
9 PL

DETAIL A



D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-2411-291

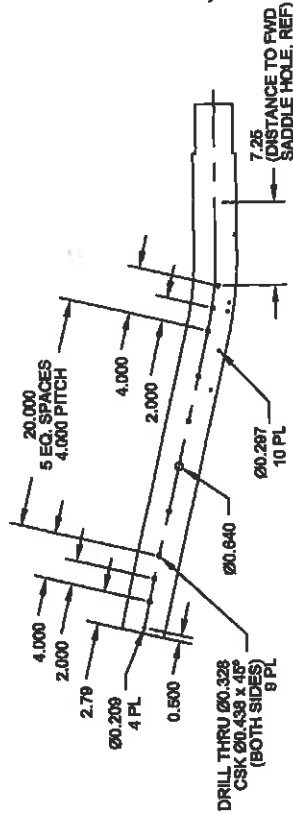
AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

D3401-041
TOW CAP

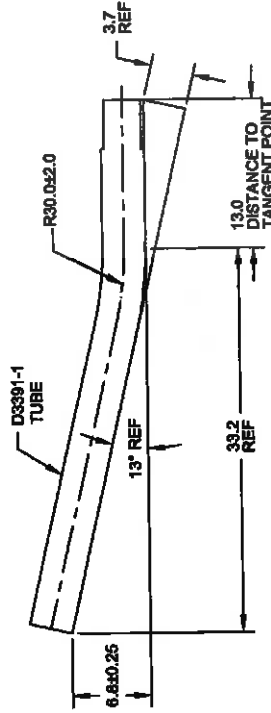
DETAIL A
SCALE 2X

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
8	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4085-051	WEARSHOE
10	AEL8-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	ML	EUGENE, OR
CHECKED	CP	DRAWING NO.
MFG. APPR.	DA	D3391
APPROVED	DA	SHEET 3 OF 11
DE APPR.	DA	SCALE
DATE	16.01.14	TITLE
		412 FLOAT SKIDTUBE

RELEASED
R 2016-04-28

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INSTALL D3870-4200 SPACER
SEAL WITH MAGNABOND 6386
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B

INSTALL
AELS-1032-225
AFTER FINISH
10 PL

D4085-051
WEARSHOE

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-2411-281

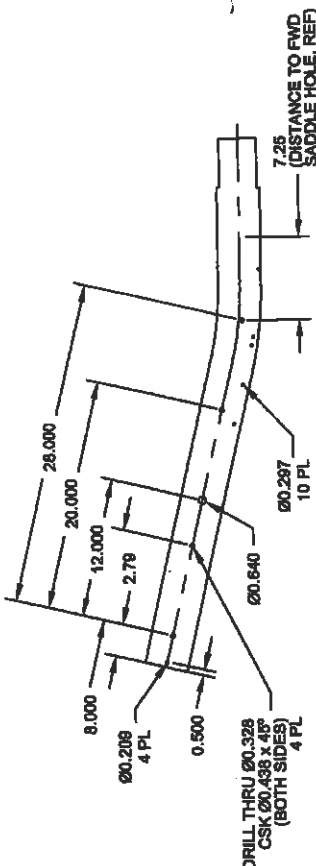
AN3C4A BOLT
D3872-1 WASHER
NAS1149C0332R WASHER
4 PL

D3401-041
TOW CAP

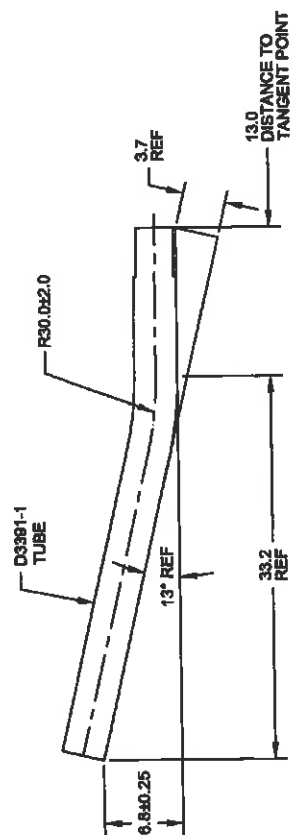
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3870-4200	SPACER
4	D3872-1	WASHER
1	D4085-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-021 DRILLING DETAIL



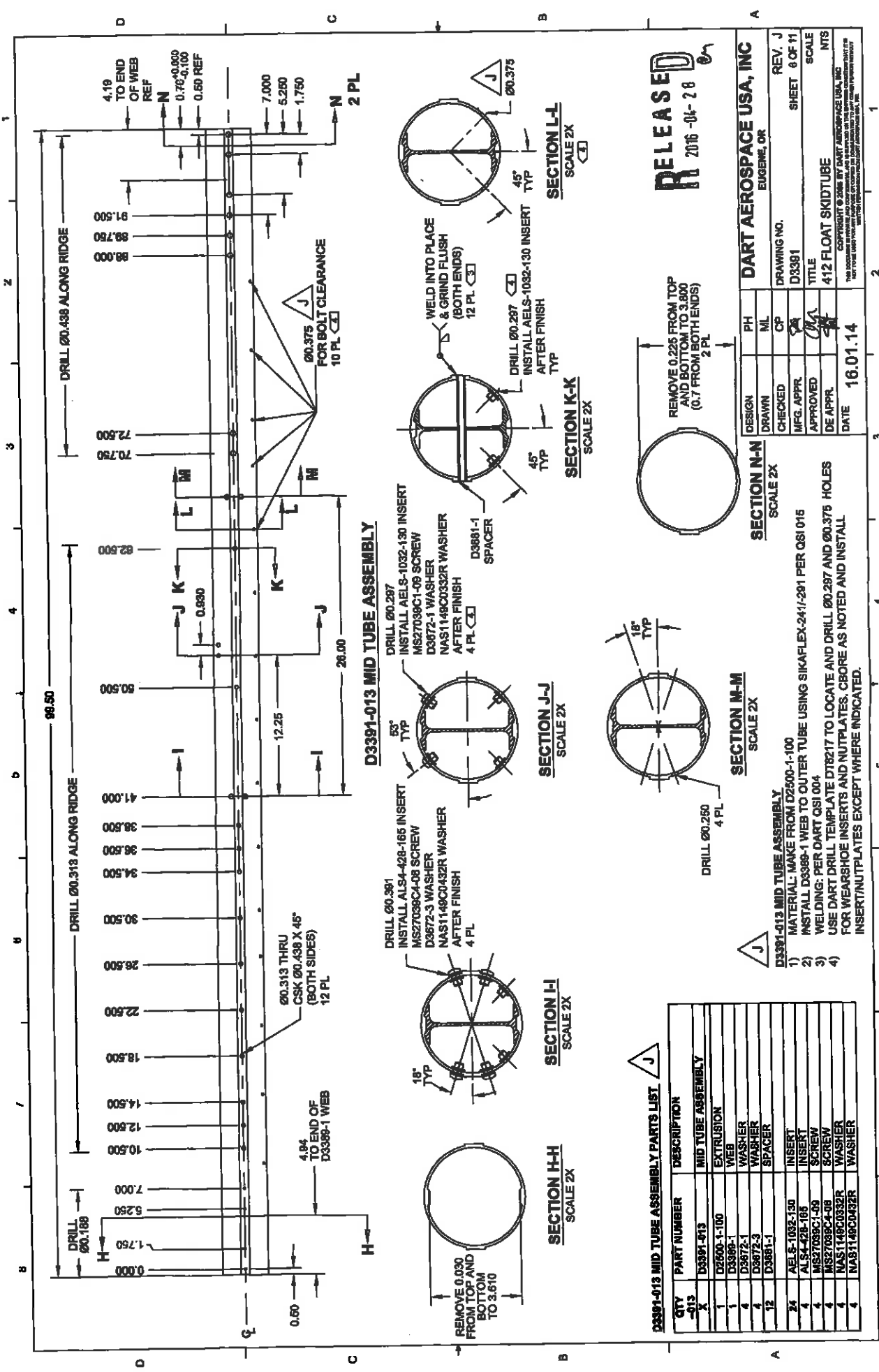
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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MFG. APPR.		D3391	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14		

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R 2016-04-28

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D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-1	EXTRUSION
1	D3391-2	WEB
1	D3391-3	WASHER
1	D3391-4	SPACER
1	D3391-5	INSERT
1	D3391-6	INSERT
1	D3391-7	SCREW
1	D3391-8	SCREW
1	D3391-9	WASHER
1	D3391-10	WASHER

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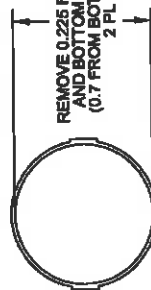
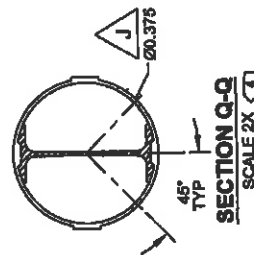
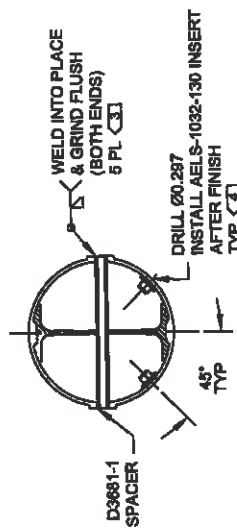
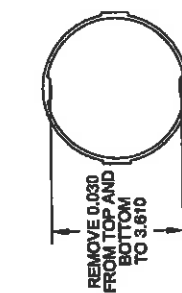
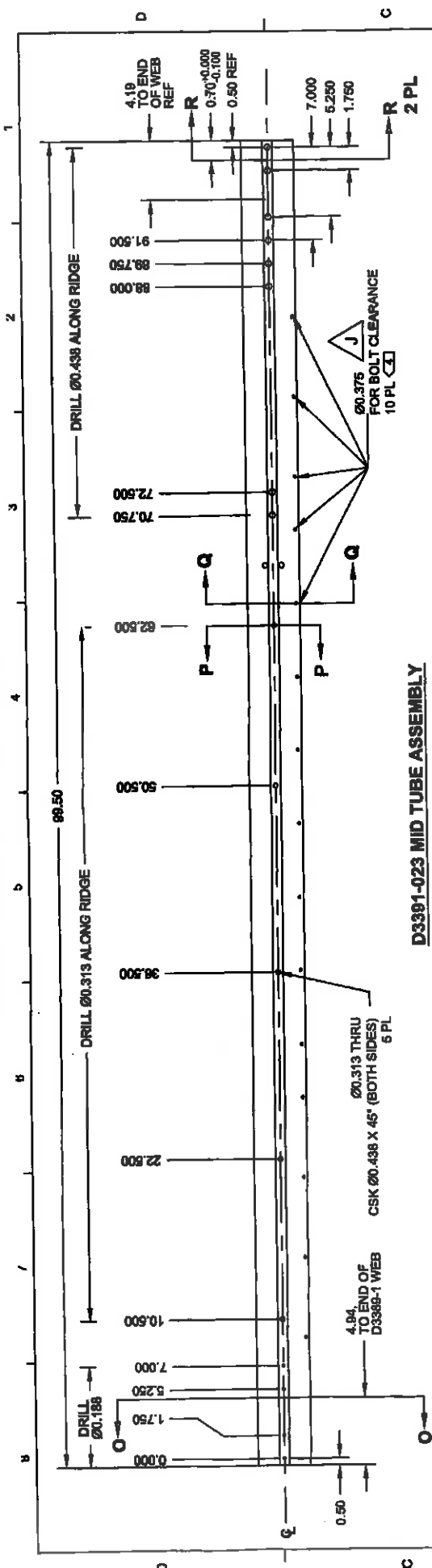
D3391-013 MID TUBE ASSEMBLY

1) MATERIAL: MAKE FROM D2500-1-100

2) INSTALL D3396-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015

3) WELDING: PER DART QSI 004

4) USE DART DRILL TEMPLATES AND DRILL Ø0.287 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.



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D03001-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
4223		
X	D3397-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AEI S-1032-130	INSERT

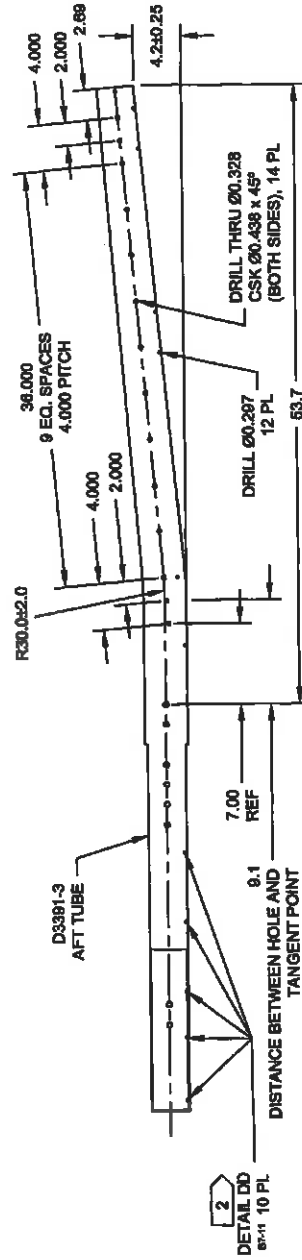
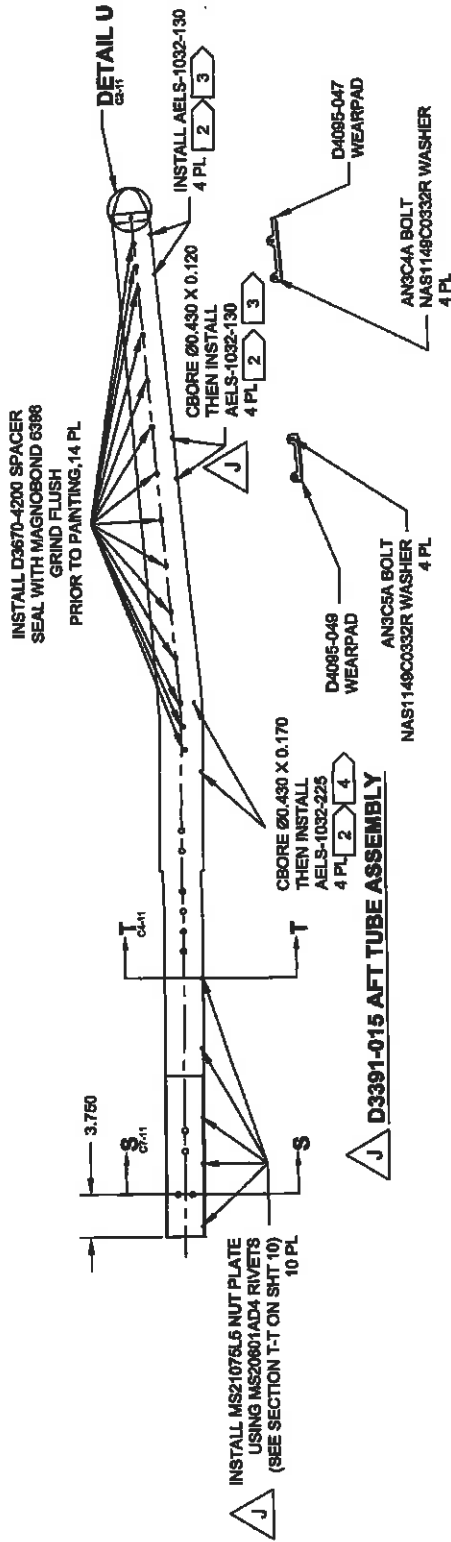
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2600-1-100
- 2) INSTALL D3398-1 WEB TO OUTER TUBE USING SIKAFLEX-241-281 PER QSI 015
- 3) WELDING: PER PART QSI 004
- 4) USE DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.287 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

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7-2	7-2	D3381	SHEET 7 OF 11
APPROVED	7-2	TITLE	SCALE
7-2	7-2	412 FLOAT SKIDTUBE	NTS
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J BENDING AND DRILLING DETAIL

D3391-015 AFT TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
2	D3391-015	AFT TUBE ASSEMBLY
1	D2648	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D5672-1	WASHER
1	D4085-049	WEARPAD
1	D4085-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	AL34-426-165	INSERT
6	AN3C4A	BOLT
20	MS20801AD4	RIVET, BLIND
19	MS21075L6	NUT PLATE, FLOATING
10	NAS1148C0332R	WASHER

J NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

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DRAWING NO.							D3391
SHEET							8 OF 11
SCALE							412 FLOAT SKIDTUBE
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7016-04-28

QTY	PART NUMBER	DESCRIPTION
1	D3961-426	AFT TUBE ASSEMBLY
1	D0448	AFT CAP
1	D0633-3	AFT TUBE
4	D3970-2000	SPACER
2	D0634	WASHER
2	D0635-249	WEARPAD
1	D0058-247	WEARPAD
8	ASL5-1032-190	INSERT
4	ASL6-1032-226	INSERT
6	ANR5-24	BOLT
4	ANR5-24	BOLT
30	ANR5001A104	RIWT, BLIND
10	MS81076L5	MS1 PLATE FLOATING
10	NAS11490-00235R	WASHER

QTY	PART NUMBER	DESCRIPTION
1	D3961-426	AFT TUBE ASSEMBLY
1	D0448	AFT CAP
1	D0633-3	AFT TUBE
4	D3970-2000	SPACER
2	D0634	WASHER
2	D0635-249	WEARPAD
1	D0058-247	WEARPAD
8	ASL5-1032-190	INSERT
4	ASL6-1032-226	INSERT
6	ANR5-24	BOLT
4	ANR5-24	BOLT
30	ANR5001A104	RIWT, BLIND
10	MS81076L5	MS1 PLATE FLOATING
10	NAS11490-00235R	WASHER

NOTES:
1) COAT
2) USE D
FOR W
WHERE
3) ENSU
4) ENSU

- NOTES:**
 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
 2) USE DART DRILL TEMPLATE DTR217 TO LOCATE AND DRILL Ø0.287 AND Ø0.375 HOLES
 FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERTING
 WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
 3) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.130 BEFORE INSTALLING INSERT
 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

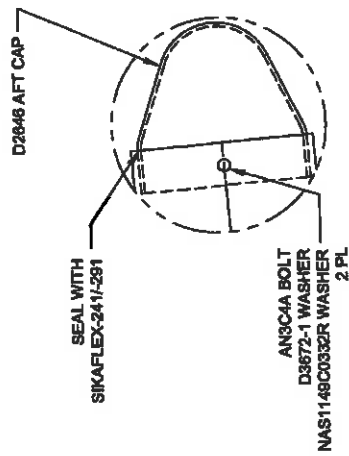


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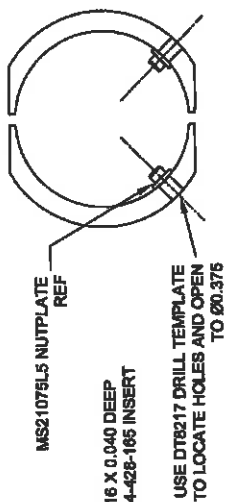
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APPROVED	<i>CP</i>	SCALE	
DE APPR.	<i>CP</i>	TITLE	
DATE	16.01.14	AFT TUBE ASSEMBLY	

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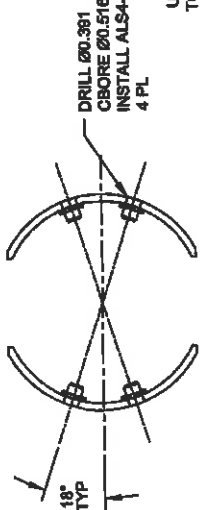
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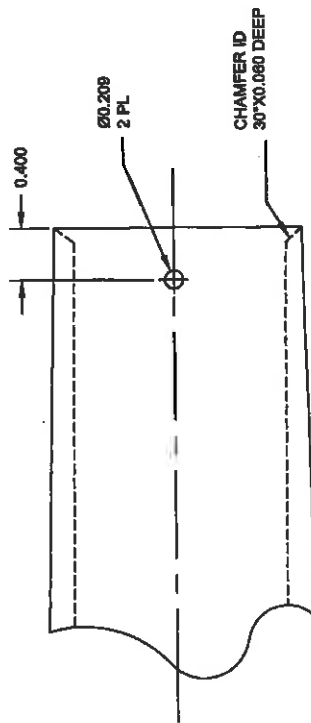
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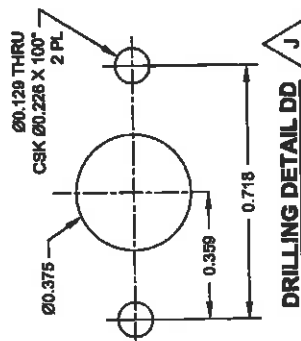
SECTION T-T
D1443
SCALE 5X
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SECTION S-S
D1443
SCALE 5X



DETAIL EE
SCALE 2X
D1441



DRILLING DETAIL DD
SCALE 10X
D1442

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NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.